Amendments to the Claims:

The listing of claims will replace all prior versions, and listings, of claims in the application:

Listing of Claims:

Claim 1 (currently amended): A method for ~~the production of~~ producing a vehicle component~~, particularly a chassis frame (1),~~ which ~~is equipped with~~ includes spring strut mountings, ~~(44), of an off-road vehicle, in which~~ elongate[[,]]; wherein:

horizontally disposed spaced apart parallel elongate tubular longitudinal member hollow profiles ~~(2, 3, 39, 40), which run parallel and are spaced apart from one another in the horizontal plane,~~ are connected nonreleasably to one another at [[the]] respective longitudinal ~~member end~~ ends thereof, by tubular cross member hollow profiles; ~~(4, 41),~~

~~in which~~ a hollow-profile-like crossbar [[(5)]] for receiving a rear axle, a differential and a transverse link, and a hollow-profile-like crossbar [[(15)]], which is spaced apart in the longitudinal direction and is ~~intended for the securing of~~ adapted to secure a vehicle transmission between the two end-side cross member hollow profiles ~~(4, 41)~~, are secured on the longitudinal member hollow profiles; ~~(2, 3, 39, 40),~~

~~in which the~~ size and shape of the cross section of the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are formed in an expanding manner by means of internal high pressure forming[[,]];

~~in which~~ body mountings ~~(6, 7, 24, 42)~~ of the frame [[(1)]] are formed by forming secondary shaped elements laterally from the longitudinal member hollow profile ~~(2, 3, 39, 40)~~ by ~~means of exertion of~~ application a fluidic internal

high pressure and subsequent vertical perforation of the secondary shaped elements~~, in which the~~;

unperforated secondary shaped elements, which contain ~~the side~~ an edge [[(22)]] of the upper side [[(23)]] of the respective longitudinal member hollow profile ~~(2, 3, 39, 40), are, after they~~ are formed, and are thereafter pinched flat [[with]] such that a radially protruding sheet-metal fold ~~(25) being~~ is formed[[,]]; and

~~in which~~ bearing mountings ~~(19, 43)~~ of longitudinal links are likewise formed, as secondary shaped elements, laterally outward from the longitudinal member hollow profile ~~(2, 3, 39, 40)~~ by ~~means of~~ fluidic internal high pressure, and are subsequently perforated.

Claim 2 (currently amended): The method as claimed in claim 1, ~~characterized in that~~ wherein the body mounting ~~(6, 7, 24, 42)~~ is pinched flat in an internal high pressure forming die by closing the die with the radially protruding sheet-metal fold [[(25)]] being formed.

Claim 3 (currently amended): The method as claimed in ~~either of claims 1 and 2, characterized in that the perforations of~~ claim 1, wherein the body mountings, ~~(6, 7, 24, 42), of~~ the bearing mountings, ~~(19, 43) of~~ the longitudinal links, and [[of]] the spring strut mountings ~~(44) take place by means of~~ are perforated by hole punches which are integrated into [[the]] an internal high pressure forming die, in which the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are formed by internal high pressure.

Claim 4 (currently amended): The method as claimed in ~~one of claims 1 to 3, characterized in that~~ claim 1, wherein:

the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are doubled by being bent through 180° about a horizontal axis running transversely, so that [[the]]

two resultant hollow profile strands ~~(28, 29, 61, 63)~~ come to lie on each other[[,]]; ~~with the~~

body mountings ~~(6, 7, 24, 42)~~ and [[the]] bearing mountings ~~(19, 43)~~ of the longitudinal links [[being]] are formed on the hollow profile strand ~~(28, 61)~~ situated on top[[,]]; and [[the]]

bent edges ~~(30, 46) forming~~ form the ends of the longitudinal members of the frame [[(1)]].

Claim 5 (currently amended): The method as claimed in claim 4, ~~characterized in that;~~ wherein:

before [[the]] bending ~~in that region~~ of the longitudinal member hollow profile, ~~(2, 3, 39, 40) which is indirectly adjacent to the bent edge (30, 46),~~ depressions ~~(33, 34)~~ are introduced into the longitudinal member hollow profile ~~(2, 3, 39, 40)~~ mechanically by [[means]] one of a punch [[or by]] and internal high pressure forming thereof, ~~into which depressions~~ and the respective cross member hollow profile ~~(4, 41)~~ is placed into said depressions; and[[,]]

after the bending operation, the respective cross member hollow profile is extensively enclosed.

Claim 6 (currently amended): The method as claimed in claim 4, ~~characterized in that, before the~~ wherein:

before bending ~~in the region~~ of the longitudinal member, in which the crossbars ~~(5, 15)~~ are arranged, depressions ~~(31, 32)~~ are introduced into the longitudinal member hollow profile ~~(2, 3, 39, 40), into which depressions,~~ and the respective crossbar ~~(5, 15)~~ is placed into said depressions; and[[,]]

after the bending ~~operation~~, the cross bar is extensively enclosed.

Claim 7 (currently amended): The method as claimed in ~~one of claims 1 to 6, characterized in that~~ claim 1, wherein:

the crossbar ~~(5, 15)~~ is formed from an oval tube~~, with, first of all, the~~;

a central region [[(67)]] of at least one longitudinal side [[(9)]] of the oval tube ~~being~~ is pressed in by means of a punch until [[the]] its longitudinal sides ~~(9, 10)~~ come to bear against each other~~, after which the end~~;

thereafter, side cavities ~~(11, 12)~~ which arise are expanded by ~~means of~~ applying internal high pressure, with the longitudinal sides ~~(9, 10)~~ continuing to bear against each other, to form tubes [[(68)]] which run parallel and have an approximately circular cross section; and [[then,]]

in [[the]] a central region [[(67)]] of the longitudinal sides ~~(9, 10)~~, the rear axle mountings [[(14)]], the holes [[(16)]] of the securing mountings for the differential and the securing holes [[(8)]] for securing the transmission are punched out or produced by metal-cutting.

Claim 8 (currently amended): The method as claimed in ~~either of claims 5 and 6, characterized in that, after the encircling of~~ Claim 5, wherein:

the cross member hollow profiles ~~(4, 41)~~ and the crossbars ~~(5, 15) by the operation of~~ are encircled by bending the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ through 180°; ~~and after the securing of the~~

resultantly formed longitudinal member hollow profile strands ~~(28, 29, 61, 63)~~ are secured on one another[[,]]; and

thereafter, at least one of the latter is expanded by ~~means of~~ applying internal high pressure until ~~a nonreleasable press fit of~~ the cross member hollow profiles ~~(4, 41)~~ and [[of]]the crossbars ~~(5, 15)~~ in [[the]] leadthroughs formed by the depressions ~~(31, 32, 33, 34)~~ of the longitudinal member hollow profiles ~~(2, 3, 39, 40) arises~~ are nonreleasably press fitted together.

Claim 9 (currently amended): The method as claimed in claim 8, ~~characterized in that~~ wherein, during [[the]] expansion of the longitudinal member hollow profile strands ~~(28, 29, 61, 63)~~, one of the cross members ~~(4, 41) and/or~~ and the crossbars ~~(5, 15)~~ of hollow design are acted upon from [[the]] inside with a deformation-preventing, fluidic counterpressure.

Claim 10 (currently amended): The method as claimed in ~~either of claims 5 and 6, characterized in that~~ claim 5, wherein one of the cross members ~~(4, 41) and/or~~ and the crossbars ~~(5, 15)~~ of hollow design are expanded [[with]] by a fluidic high pressure at [[the]] a location of [[the]] leadthroughs formed by the depressions ~~(31, 32, 33, 34)~~ of the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~.

Claim 11 (currently amended): The method as claimed in claim 10, ~~characterized in that~~ wherein, during [[the]] expansion of one of the cross members ~~(4, 41) and/or~~ and of the crossbars ~~(5, 15)~~, the two hollow profile strands ~~(28, 29, 61, 63)~~ of the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are acted upon with a deformation-preventing, fluidic counterpressure.

Claim 12 (currently amended): The method as claimed in ~~one of claims 1 to 11, characterized in that~~ claim 1, wherein, in the case of a two-part design of the frame [[(1)]] with a division between the crossbars ~~(5, 15)~~, the mutually facing ends ~~(18, 45, 66)~~ of the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are inserted one inside another and are subsequently connected nonreleasably to one another.

Claim 13 (currently amended): The method as claimed in claim 12, ~~characterized in that the ends (18, 45, 66)~~ wherein one of the following is true:

ends which are inserted one inside another are welded to one another [[or,]]; and

after forming at least one form-fitting element at [[the]] an end ~~(45, 66)~~ receiving the end [[(18)]] to be inserted by means of internal high pressure with a shape-negative mating form-fitting element being formed, are fixed in a form-fitting manner at the location of the form-fitting element.

Claim 14 (currently amended): The method as claimed in ~~one of claims 1 to 13, characterized in that the~~ claim 1, wherein:

a spring strut mounting [[(44)]] of the frame [[(1)]] is formed from the longitudinal member hollow profile; ~~(39, 40), with~~

the ~~latter being~~ longitudinal member hollow profile is bent upward by an angle of at least 90° on a section [[(50)]] at a location about a horizontal axis [[(52)]], which intersects the central longitudinal axis [[(51)]] of the hollow profile ~~(39, 40)~~ at an angle of approximately 45°, such that the hollow profile ~~(39, 40)~~ protrudes laterally [[there]], with regard to its essentially rectilinear directional profile, outside the spring strut mounting; ~~(44), after which the~~ and

thereafter, lateral excess length is angled in order to form the spring strut mounting ~~(44) after a certain~~ with a preset height offset ~~with respect~~ relative to the hollow profile ~~(39, 40)~~ running outside the spring strut mounting [[(44)]].

Claim 15 (currently amended): The method as claimed in claim 14, ~~characterized in that~~ wherein:

the longitudinal member hollow profile ~~(39, 40)~~ is formed from two separate contiguous individual hollow profiles; ~~arranged in a row next to each other, with one~~

a first half of the spring strut mounting ~~(44) being~~ is formed by [[the]] bending and angling [[of]] one end of the one individual hollow profile~~, and with, adjoining this one half of the spring strut mounting (44), in order to form~~;

the other half of the spring strut mounting ~~(44), the~~ is formed by bending a facing end of the other individual hollow profile ~~being~~ is bent us in a mirror-inverted manner with respect to [[this]] the first half, and [[being]] is angled in the same direction[[,]]; and

thereafter ~~after which~~ the two halves are connected fixedly to each other.

Claim 16 (currently amended): The method as claimed in claim 14, wherein: ~~characterized in that the~~

each longitudinal member hollow profile ~~(39, 40)~~ is composed of ~~in each case~~ two contiguous separate hollow profile strands ~~(61) and (63) lying on each other, in that the one~~;

a first half of the spring strut mounting [[(44)]] is formed from [[an]] a first end [[(62)]] of the hollow profile strand [[(61)]] that is in the vicinity of the cross member; [[and]]

the other half of the spring strut mounting [[(44)]] is formed from [[an]] a second end [[(64)]], which tapers to [[this]] the first end [[(62)]], of the longer hollow profile strand, ~~(63) which~~ runs essentially downward and is bent back on itself through 180°~~, in that~~;

the [[two]] first and second ends ~~(62, 64)~~ are angled about an axis parallel to the longitudinal axis of [[that]] a part of the longitudinal member hollow profile ~~(39, 40)~~ which does not belong to the spring strut mounting [[(44)]] and is situated next to it[[,]]; and ~~in that~~,

after they are flattened at their point of abutment, the first and second ends ~~(62, 64)~~ bearing against each other are connected nonreleasably~~, preferably welded~~.

Claim 17 (currently amended): The method as claimed in claim 14, ~~characterized in that~~

the spring strut mounting [[(44)]] of the frame [[(1)]] is formed as a single piece from the longitudinal member hollow profile, which is ~~(39, 40), with the longitudinal member hollow profile (39, 40) being~~ bent back at both ends through 180°[[,]]; ~~and in that its ends~~

extremities of the longitudinal member hollow profile subsequently are bent in a mirror-inverted manner with respect to one another about the horizontal axis [[(52),]];

~~with in each case~~ one half of [[the]] each spring strut mounting ~~(44) being~~ is formed, and [[are]] angled in the same direction~~, after which~~; and

thereafter, the halves bearing laterally against each other are connected fixedly to each other.

Claim 18 (currently amended): The method as claimed in claim 14, ~~characterized in that the~~ wherein:

a radially protruding section [[(50)]] is bent forward through approximately 90°; [[-]] parallel to [[the]] a longitudinal direction of the longitudinal member hollow profile, ~~(39, 40)~~ [[-]] about a further parallel axis [[(53)]] spaced apart vertically from the horizontal axis [[(52)]], so that a subsection [[(54)]] of the radially protruding section [[(50)]] lies approximately parallel to [[the]] a longitudinal extent of the remaining longitudinal member hollow profile ~~(39, 40)~~ adjoining the spring strut mounting [[(44)]], but with a height and lateral offset thereto, with the one half of the spring strut mounting [[(44)]] extending as far as the center of the subsection [[54),]]; and ~~in that the~~

production of the other half of the spring strut mounting [[(44)]], which half runs from the center of the subsection [[(54)[[in the direction of [[the]] a front cross member [[(41)]], takes place by mirror-inverted further bending of the section [[(50)]] following the subsection [[(54)]].

Claim 19 (currently amended): The method as claimed in ~~one of claims 14 to 18, characterized in that~~ claim 18, wherein the lateral excess length is angled into a horizontal plane.

Claim 20 (currently amended): The method as claimed in ~~one of claims 14 to 19, characterized in that~~ claim 19, wherein the angled portion is flattened.

Claim 21 (currently amended): The method as claimed in claim 20, ~~characterized in that~~ wherein the flattened portion is perforated.

Claim 22 (currently amended): The method as claimed in ~~either of claims 20 and 21, characterized in that~~ claim 21, wherein the flattened portion [[(65)]] of the ends ~~(62, 64)~~ is bent downward at a right angle on the end side.

Claim 23 (currently amended): The method as claimed in ~~one of claims 14 to 22, characterized in that,~~ claim 22, wherein:

after [[the]] bending of the longitudinal member hollow profile ~~(39, 40)~~ to form the spring strut mounting [[(44)]], the ~~latter~~ spring strut mounting is acted upon at both ends by internal high pressure[[, with]]; the cross section of the longitudinal member hollow profile, which is severely crushed during the bending[[,]] of its two struts, producing ~~(58, 59), which produce~~ the height offset with respect to the remaining longitudinal member hollow profile, is ~~(39, 40), being~~ expanded to form a circular cross section in rough approximation.

Claim 24 (currently amended): The method as claimed in ~~one of claims 1 to 23, characterized in that~~ claim 23, wherein form-fitting elements in the form of depressions~~, preferably channels (38),~~ are formed on [[the]] upper sides of the longitudinal member hollow profiles ~~(39, 40)~~ by means of a punch.

Claim 25 (currently amended): The method as claimed in claim 24, ~~characterized in that~~ wherein mating form-fitting elements~~, preferably ribs (37)~~ from the depression-free hollow profile strand, are formed in the form-fitting

elements by ~~means of~~ internal high pressure forming, after [[the]] bending to double the respective longitudinal member hollow profile ~~(39, 40)~~.